

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002063**Date Inspected:** 26-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay 7: QA Inspector witnessed ZPMC QC MT Inspectors Mr. Zhou Dong Yun and Mr. Cai Xin Xin perform 100% Magnetic Particle (MT) inspection of total weld lengths of stiffener to floor beam plate fillet welds for FB 025-001, FB 025-002, and FB 022-002 various welds. QA Inspector performed 10% minimum visual and magnetic particle inspections of portions of QC acceptable inspection of stiffener to floor beam plate fillet welds. QA Inspector found QC MT inspection method and welds inspected to be in compliance with AWS D1.5 (02) and the contract documents. For details please see Magnetic particle testing report TL-6028 dated April 26, 2008

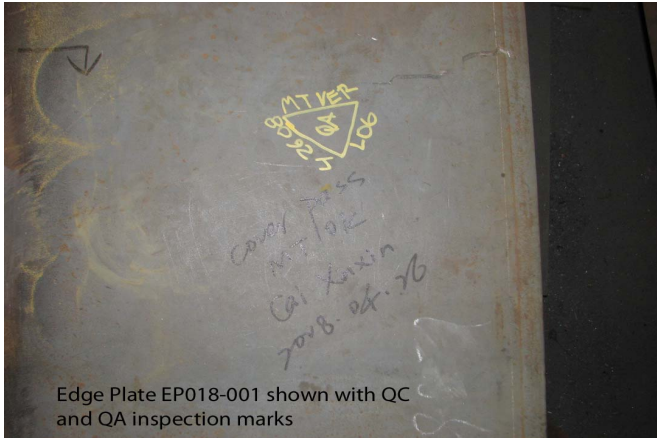
Bay 4: QA Inspector performed 10% minimum visual (VT) and magnetic particle (MT) inspections of portions of QC VT/MT acceptable inspection of stiffener to edge plate (EP) fillet welds for EP 018-001, EP 020-001, EP 003-001, EP 017-001, and EP 005-001. QA Inspector found QC MT inspected fillet welds to be in compliance with AWS D1.5 (02) and the contract documents. For details please see Magnetic particle testing report TL-6028 dated April 26, 2008.

Bay 8: QA Inspector randomly observed ZPMC qualified welder Ma Ying ID#045270 welding cover passes on a Complete Joint Penetration (CJP) butt splice joint designation B-U3c-S on 75mm thick diaphragm plate ESD1-SA290 11B/12B. Welder was observed welding in the 1G (flat) position utilizing Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal LA85. QA Inspector observed the ZPMC QC

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Inspector Mr. Sha Zhi verifying that the welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 205°C and measured the welding parameters to be 600 amps, 30.7 volts, a travel speed of 472. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-T-3221-B-U3c-S.



Summary of Conversations:

No significant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
